

Work Order ID 64020

Tuesday, November 23, 2010 8:04:39 AM



Page 1

Item ID:	D3953-3	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Gas Spring Stud, Lid					
Start Date:	11/23/2010	Start Qty:	10.00			
Required Date:	11/30/2010	Req'd Qty:	10.00			
Reference:						

Approvals:	Process Plan:		Date:	10-11-3	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3953	C								

100		0.00							
	Doosan								
Doosan Lathe	Memo	0.00				10			

Turn as per folio FA852 & DWG
FOLIO REV:
DWG REV:

DEBURR

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00				10			

Quality Control

10/12/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64020

Tuesday, November 23, 2010 8:04:39 AM

Page 2

Item ID: D3953-3

Accept

Setup Start

Revisor ID:

Stop

Item Name: Gas Spring Stud, Lid

Start Date: 11/23/2010 Start Qty: 10.00

Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 10.00

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		amt 10/12/02		10	0		
130  Packaging Packaging	Identify as per dwg & Stock Location: <u>100</u> Memo	0.00 0.00							10/12/02
140  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							10/12/03 10-12-2 10

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, November 23, 2010 8:04:43 AM

Page 1

Work Order ID: 64020

Parent Item: D3953-3

Parent Item Name: Gas Spring Stud, Lid



Start Date: 11/23/2010

Required Date: 11/30/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP RevA: New issue DD verified by:EC
per dwg revC DD 10.03.02 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304RO.750

Purchased

No

100

f

27.9947

0.125

1.315789



304 SS Roundbar .750



SA 10/12/07

Location

Loc Qty

Loc Code

MAT028

27.99473684

113216

17.8447368

113457

10.15

1.315789

Dart Aerospace Ltd

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 101020
Description: Gas Spring Stud, Lid		Part Number: D3953-3
Inspection Dwg: D3953 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.75	+/-0.030	0.751	/		Ver	SA-9
0.56	+/-0.010	.562	/		?	?
0.281	+/-0.010	.281	/		?	?
1/4-28 UNF-2A	N/A		/			
Major Ø	Max = 0.2490 Min = 0.2425	.246	/		Mic	SA-5
M.O.W.	Max = 0.26687 Min = 0.26357	.265	/		Mic	SA-5
Ø0.098	+0.004/-0.001	.100	/		Ver	SA-2
Ø0.250	+/-0.010	0.246	/		?	?
0.170	+/-0.010	.170	/		?	?
0.330	+/-0.010	.330	/		?	?
0.13	+/-0.030	.129	/		?	?
R0.06	+/-0.030	R.05	/		RG	
1.31	+/-0.030	1.305	/		Ver	SA-9

Measured by: [Signature]	Audited by: [Signature]	Prototype Approval:	N/A
Date: 10/12/01	Date: 10/12/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	
B	09.12.14	Dwg Rev updated	KJ [Signature]	[Signature]

W/O:		WORK ORDER CHANGES					
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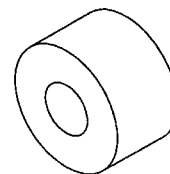
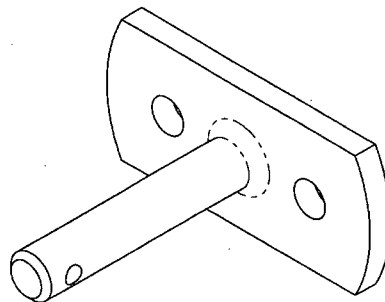
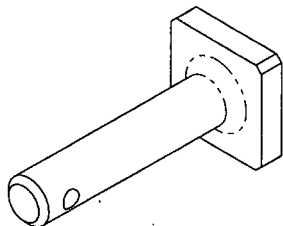
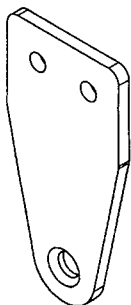
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



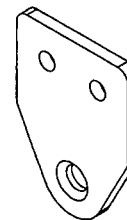
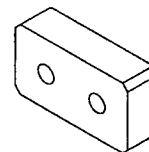
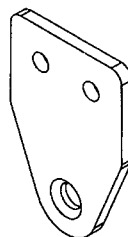
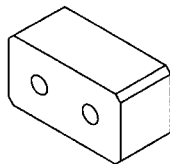
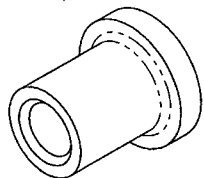
D3953-1 GAS SPRING BRACKET
(FULL LID)

D3953-3 GAS SPRING STUD, LID

D3953-5 GAS SPRING STUD, BASE

D3953-7 GAS SPRING SPACER

D3953-9 GAS SPRING WASHER



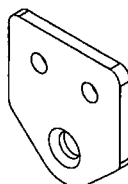
D3953-11 GAS SPRING SPACER

D3953-13 GAS SPRING SPACER
(FULL LID)

D3953-15 GAS SPRING BRACKET
(SPLIT LID)



D3953-17 GAS SPRING SPACER
(SPLIT LID)

D3953-19 GAS SPRING BRACKET
(SQUARE BASKET)



D3953-21 GAS SPRING BRACKET
(SQUARE BASKET)

RELEASED
2010-07-26

C	PARTS -19 & -21 ADDED (SHT 18 & 4); CSK CALLOUT WAS CHAM (C6-2, B6-3, C6-4); C SYMM WAS C SYM ABOUT (C7-2, C7-4); SECTION C-C REPOSITIONED TO B2-4 REASON: ADDL PARTS REQD; DRAFTING ERRORS			JPH	10.01.29
B	SHEET 3 ZONE C1, DIM 0.05 MIN WAS 0.13, MULTIPLE DIMENSIONS MIN/MAX REMOVED TOLERANCE ADDED. REASON: DIFFICULTY INSTALLING COTTER PIN AT NEXT ASSY.			AJS	09.11.11
A	NEW ISSUE			AJS	09.07.27
REV.	DESCRIPTION			BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	JPH				
CHECKED		DRAWING NO.	REV. C		
MFG. APPR.		D3953	SHEET 1 OF 4		
APPROVED		TITLE	SCALE		
DE APPR.		GAS SPRING LID COMPONENTS	NT		
DATE	10.01.29	COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. NO USE, REPRODUCTION OR DISSEMINATION OF THIS INFORMATION IS PERMITTED WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

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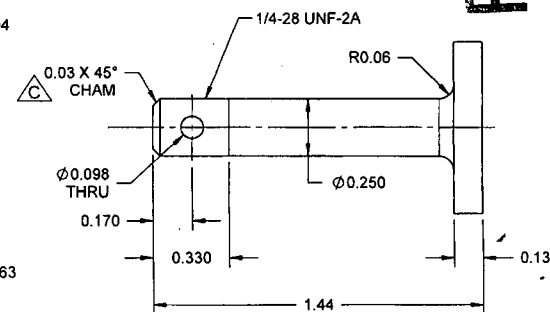
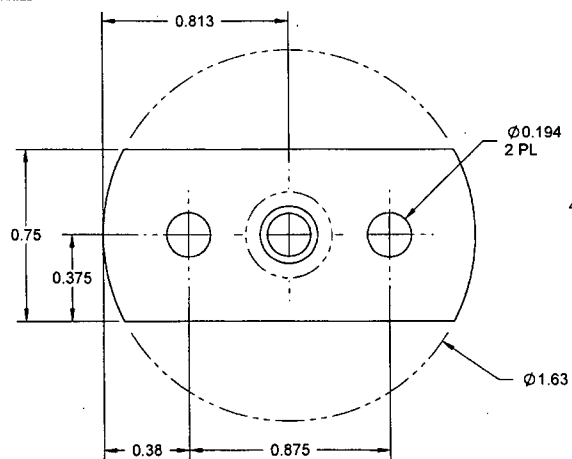
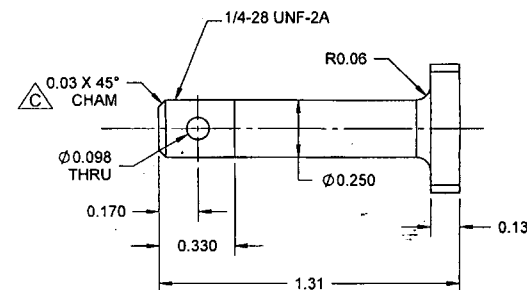
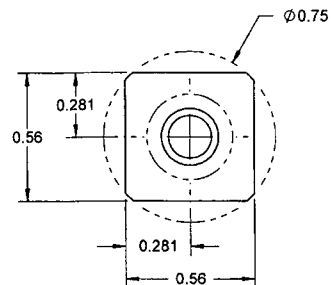
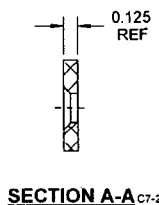
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NOTE: Date & initial all entries



2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT
 -1: 0.11 lbs
 -3: 0.03 lbs
 -5: 0.06 lbs

D3953-3 GAS SPRING STUD, LID

D3953-5 GAS SPRING STUD, BASE

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3953	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GAS SPRING LID COMPONENTS NTS	
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2010-02-26

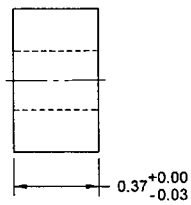
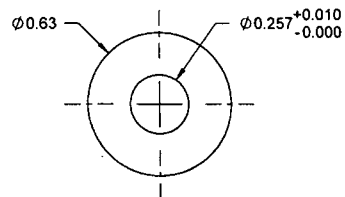
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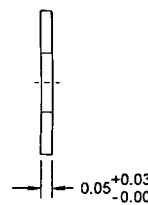
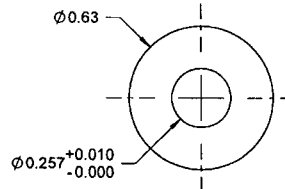
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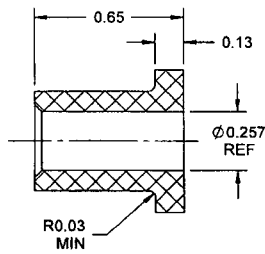
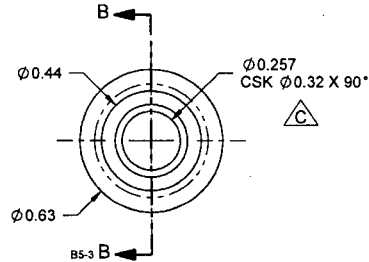
NOTE: Date & initial all entries



D3953-7 GAS SPRING SPACER

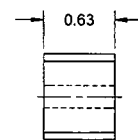
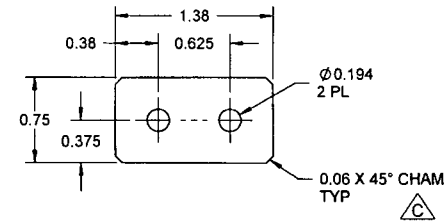


D3953-9 GAS SPRING WASHER



D3953-11 GAS SPRING SPACER

SECTION B-B B7-3



D3953-13 GAS SPRING SPACER

NOTES:

1) MATERIAL -7,-9 & -11: DELRIN II 150E OR ACETRON GP ACETAL, BLACK
REF DART SPEC M-DELIRIN-R

-13: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION -13 ONLY: IDENTIFY WITH DART P/N "D3953-13" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -7/-9/-11: < 0.01 lbs EACH
-13: 0.17 lbs

RELEASED
2010-02-26

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3953	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GAS SPRING LID COMPONENTS NTS	
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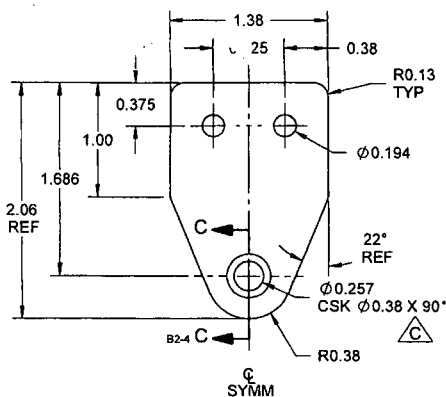
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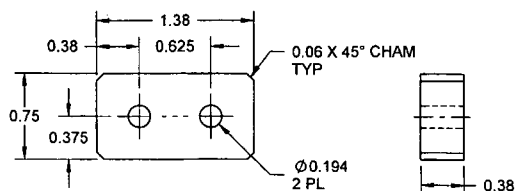
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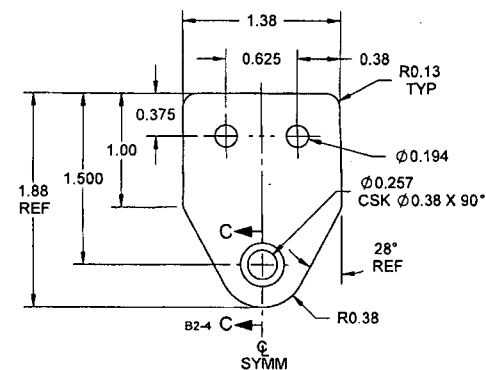
NOTE: Date & initial all entries



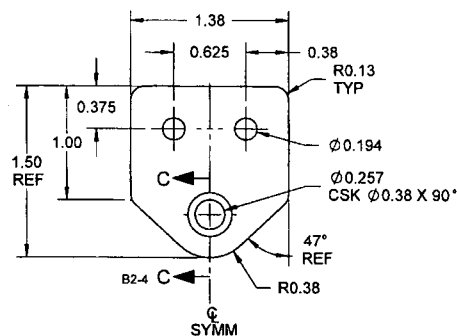
D3953-15 GAS SPRING BRACKET
(SPLIT LID)



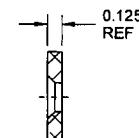
D3953-17 GAS SPRING SPACER
(SPLIT LID)



D3953-19 GAS SPRING BRACKET
(SQUARE BASKET)



D3953-21 GAS SPRING BRACKET
(SQUARE BASKET)



SECTION C-C

NOTES:

1) MATERIAL -15/-19/-21: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA

-17: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -15: 0.08 lbs
-17: 0.10 lbs
-19: 0.07 lbs
-21: 0.06 lbs

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DESIGN	AJS	DRAWING NO.	REV. C
DRAWN	JPH	D3953	SHEET 4 OF 4
CHECKED		TITLE	SCALE
MFG. APPR.		GAS SPRING LID COMPONENTS	NTS
APPROVED			
DE APPR.			
DATE	10.01.29		

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